

Date: Wednesday, 18/06/2008 1:26:39 PM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	MIRROR BRACKET
Job Number :	39920	Part Number :	D2010101
Estimate Number :	10245	Drawing Number :	D2010 PRELIM
P.O. Number :		Project Number :	N/A
This Issue :	18/06/2008	Drawing Revision :	PRELIM
Prsht Rev. :	NC	Material :	
First Issue :	/ /	Due Date :	30/06/2008
Previous Run :	39505	Qty:	20 Um: Each
Written By :			
Checked & Approved By :	JULIE LECOCQ		
Comment :	Est:E 02.06.25 Added Rev. C1 KJ/RF Est Rev:F 07-08-015 Now on WaterJet Verified By:EC Est Rev:G 08-05-27 as per ECN1195P DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S063	2024-T3 .063 sheet
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8



Comment: Qty.: 0.3646 sf(s)/Unit Total : 7.2912 sf(s)
 Material: 2024-T3 (QQ-A-250/4) 0.063" thick
 (M2024T3S.063) Batch: 107276

108415

HB 8-7-3

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D2010-101
 Dwg Rev: D
 Prog Rev: D

HB 8-7-3

21

2-Deburr if necessary

HB 8-7-3

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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HB 8-7-3

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

S 05/07/03 counter

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 Deburr

u/a
 Dore at step #22
 S 05/07/03

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: MIRROR BRACKET

Job Number: 39920

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



(PD) →

Comment: NC BRAKE

Form as per Dwg D2010

SB 08/07/07

FE032EF

Inserts



Comment: Qty.: 4.0000 Each(s)/Unit Total : 80.0000 Each(s)

Inserts

Pick:

Qty Part Number

Description

Batch

4 FE-032-EF

Insert

M10 7896 64 M10 8313 78

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install fasteners per Dwg D2010

08/07/10 (21)

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/07/11 (21) counter

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

11:30

OVEN TEMPERATURE:

320

FINISH TIME:

12:00

08/07/09

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

08/07/10 (21) counter

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 228

08/07/11 (21)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08/07/08	6.1	Inspect DC #5	S	08-07-08	21	E	08/07/08
	7.0	Chemical coat as per QS7005	/BR	08-07-08	21	E	08/07/08

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



08/07/14 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-07-11

Dart Aerospace Ltd

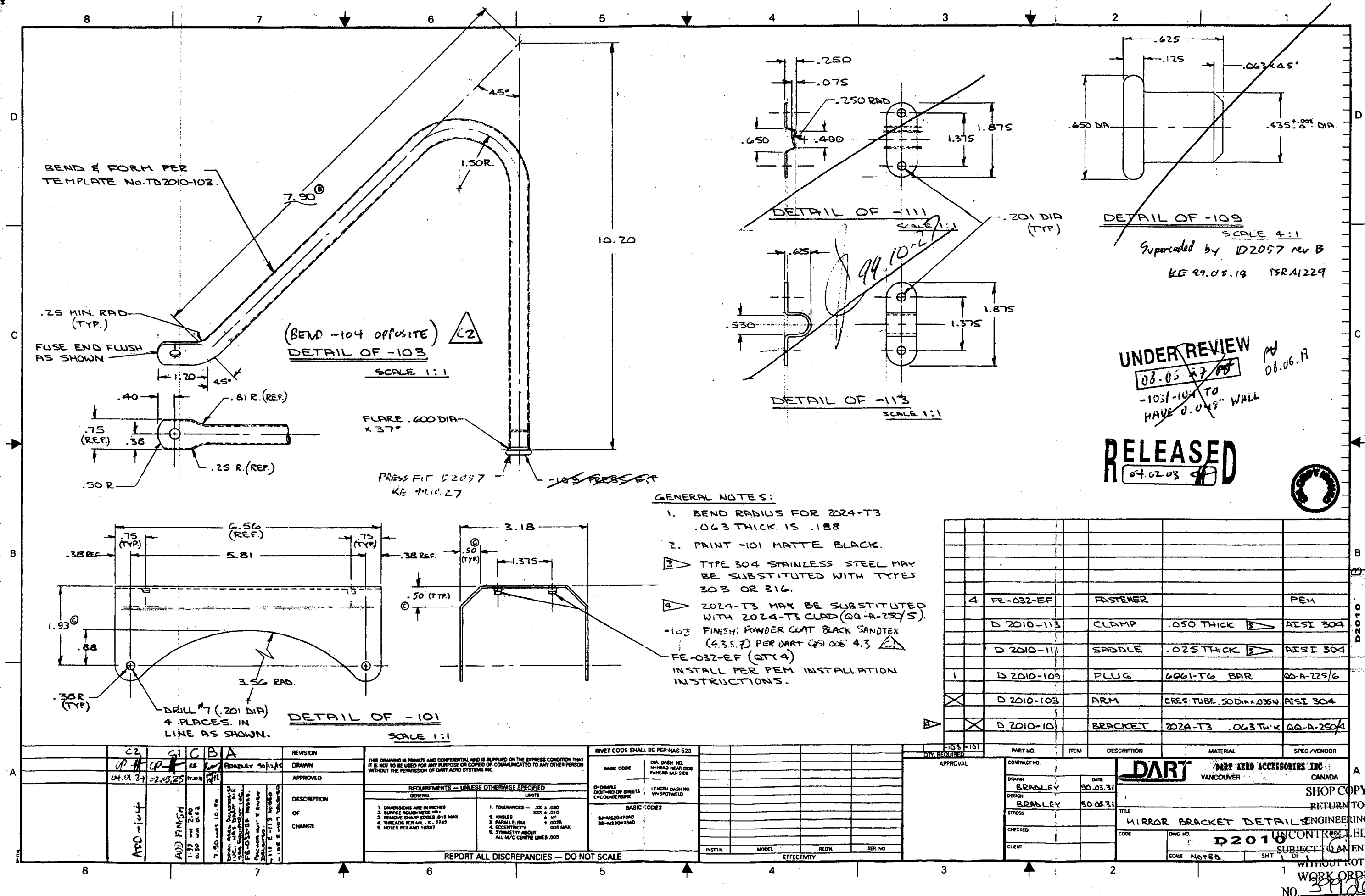
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



UNDER REVIEW
08-05-77
-1081-104 TO
HAVE 0.048" WALL

RELEASED
04.02.03

[illegible][illegible]

CANADA
 SHOP COPY
 RETURN TO
 AIRS ENGINEERING
 IN CONTROLLED COPY
 SUBJECT TO AMENDMENT
 OF
 1 WITHOUT NOTICE
 WORK ORDER
 NO. 39120

